



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

644.4122

Job Sheet 181925



Part No: 644.4122

Job Qty: 30 ea

Part Name: EC145 Fwd Crosstube Bushings



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 644.4100 REV F2 IPP REV:A NEW ISSUE 16-12-07 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Machining-1		K19/27 JBD
100	Lathe Conv	30 pcs	8/31/18	8/31/18	0.00	100.00	Lathe Conv-1		
110	QC	30 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-1		
120	QC	30 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-1		
130	Outsource	30 pcs	8/31/18	8/31/18			ATG001-VC	8	A-18-09-28 OCT 01 2018
140	Packaging	30 pcs	8/31/18	8/31/18	0.00	0.00	Packaging2		OCT 05 2018
150	QC	30 pcs	8/31/18	8/31/18	0.00	0.00	QC6		OCT 05 2018
160	Packaging	30 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		OCT 05 2018
170	QC21-SA	30 Ea	8/31/18	8/31/18	0.00	0.00	QC21		OCT 05 2018

Part Op 100 - 1-TURN AS PER DWG DWG REV: ***** 2- deburr and break all sharp

Descriptions: edges

130 - 1-ISSUE P/O TO ATG 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625
Type 3 Class 2 3-Certification of Conformity is required

160 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	10.2300 ft (.341 ea)	90-Start up Operation	5114087

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625	10	129	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Bushing	0.550inches + 0.000 - 0.003	0.550 0.547	Diameter	
2	Fwd Crosstube Bushing	0.470inches + 0.000 - 0.003	0.470 0.467	Diameter	
3	Fwd Crosstube Bushing	0.500inches ± 0.010	0.510 0.490		
4	Fwd Crosstube Bushing	0.333inches	0.339	Diameter	

			+ 0.006	0.332	
			- 0.001		
5	Fwd Crosstube Bushing	3.746inches	+ 0.000 - 0.003	3.746 3.743	
6	Fwd Crosstube Bushing	0.031inches	± 0.010	0.041 0.021	
7	Fwd Crosstube Bushing	45.000Degrees	± 0.500	45.500 44.500	Angle

Plex 8/13/18 2:34 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use as is ☐	Skid-tube ☐ Machining ☐ Threading ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
		ve : _____	MRB (QSI042) Approval _____ _____ _____		
		Disposition _____ _____ _____	Completed By _____ _____ _____		
		Lead hand / Supervisor Approval Verification _____ _____ _____			
		QC / QA Coordinator Approval _____ _____ _____			
Part: 644,4122 Job No: 181925 Serial No/Batch: S114087 Revision: F2 Inspector: _____ Exp Date: _____ Instructions: _____ Date: 09/27/18 DART AEROSPACE Container No: S114087 12210 Aberdeen Street New Bedford, MA 01945 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Dart Aerospace Ltd. 12210 Aberdeen Street New Bedford, MA 01945 TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com					
FAULT CATEGORY					
Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Onset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041186**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041186
PO Date: 10/1/18
Due Date: 10/12/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182799	RBEM632V4000102-3	Clamp Base -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$4.77/pcs	\$28.62
2	181923	644.4119	Spacer, Fwd Stop 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	50 pcs	0 pcs	50 pcs	\$4.17/pcs	\$208.50
3	181918	644.4113	Spacer, Stop 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$3.87/pcs	\$116.10



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada
Tel (613) 632-5200

PURCHASE ORDER PO041186

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	181925	644.4122	EC145 Fwd Crosstube Bushings 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$5.82/pcs	\$174.60
5	182800	RBEM632V4000102-5	Clamp Top -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	6 pcs	0 pcs	6 pcs	\$4.77/pcs	\$28.62
6	181926	644.4123	EC145 Fwd Crosstube Bushing 1-ISSUE P/O TO ATG: 2-Anodize Black -MPP-172 Section 2.1 -Hard Anodize IAW Mil-A-8625 Type 3 Class 2 3-Certification of Conformity is required	Firmed	-	10/12/18	30 pcs	0 pcs	30 pcs	\$5.82/pcs	\$174.60
7	180171	RBE350A94-3301-00	Tail Rotor Accelerator Support -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	10/12/18	20 pcs	0 pcs	20 pcs	\$4.477/pcs	\$89.54
Grand Total:											\$820.58



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO041186

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/2/18 1:54 PM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916175

Date: 04-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
50 ea	Part: 644.4119 ✓ Spacer, Fwd Stop Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 23835	Rev: F PO: PO041186 ✓	Line: 2
30 ea	Part: 644.4113 ✓ Spacer, Stop Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 23836	Rev: F PO: PO041186 ✓	Line: 3
30 ea	Part: 644.4122 ✓ EC145 Fwd Crosstube Bushings Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 23837	Rev: F PO: PO041186 ✓	Line: 4
31 30 ea	Part: 644.4123 ✓ Bushings Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Job: 23839	Rev: F PO: PO041186 ✓	Line: 6
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>4/10/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

DAS
68
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916175

Date: 04-Oct-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
Made in Canada.		